

118
78

Work Order ID 72135

Tuesday, July 19, 2011 12:44:05 PM



Page 1

Item ID:	D2877	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle Spacer					
Start Date:	7/19/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	7/25/2011	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-07-19	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2877	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2877 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-deburr

6061-125

B11-8-10

48

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-10

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Smolli

Locusts
448

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72135



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Tuesday, July 19, 2011 12:44:05 PM

Item ID: D2877

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 7/19/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab Memo Deburr if necessary	0.00 <i>N/A</i>							
140 HandFinish	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
Hand Finishing									
150 QC	QC3- Inspect Part Finish Memo	0.00 0.00							
Quality Control									

48 4 30 11/08/11

48 X 10 m 11/08/11

W/O:		WORK ORDER CHANGES					
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Work Order ID 72135



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Tuesday, July 19, 2011 12:44:05 PM

Item ID: D2877

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 7/19/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>028</u>	0.00							
	Packaging	0.00							
	Memo								
	Packaging								
170	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Quality Control								

11/18/12 (48)

CK 11/08/12

11-08-12 (48)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 12:44:11 PM

Page 1

Work Order ID: 72135



Parent Item: D2877



Parent Item Name: Saddle Spacer

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP B ☐ 00.05.19 ☐ Added inspect level 8 ☐ EC
 IPP C ☐ 06.04.26 Water jet ☐ EC
 IPP Rev:D Now M6061-T6 06-06-23 JLM
 IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			110	sf	147.5514	0.0607	2.555789	3,		
6061-T6 .125 Sheet													

B11-8-10

Location

Loc Qty

Loc Code

MAT021

147.5513684

113608

77.17

116700

6.38136842

118217

64

118217

48

Dart Aerospace Ltd

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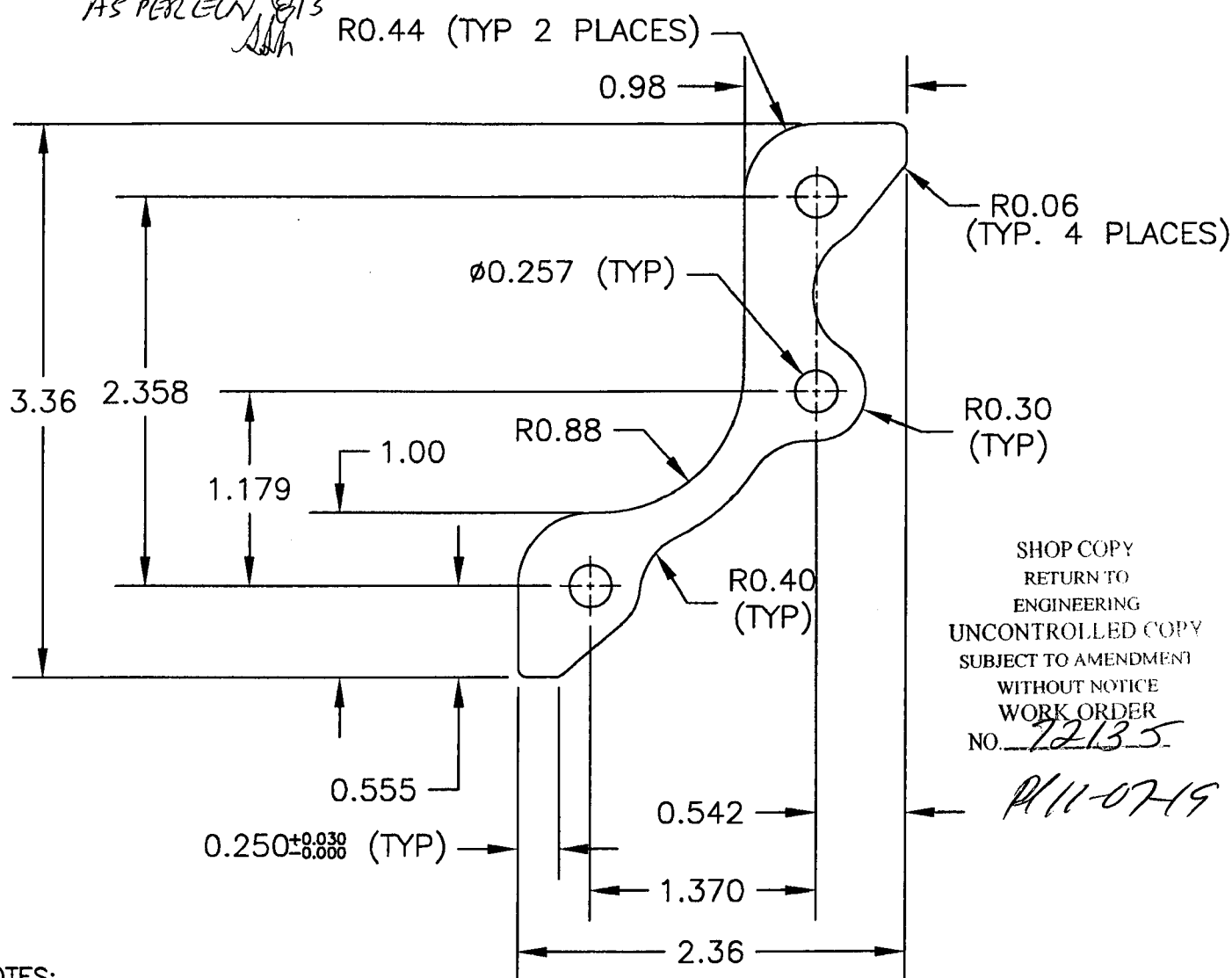
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED
06.06.21

AS PER ECN 813
[Signature]



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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